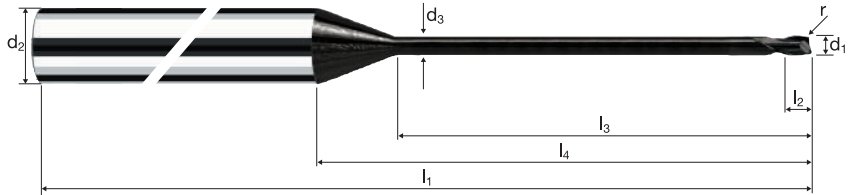


# Corner radius end mills MicroX

Shank  $\varnothing$  6mm, cylindrical neck, 20xd



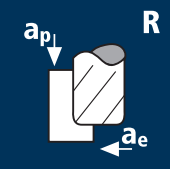


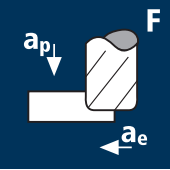





HM  $\lambda$  30°  
XA  $\gamma$  15°



C Graphite CF/GF Fiber Reinforced Plastics

IV

Example: Order-N°.											DIAPLUS
Coating: <b>B</b> Article-N°: <b>6044</b> ø-Code: <b>040</b>											<b>B6044</b>
Ø Code	d <sub>1</sub> 0/-0.01	d <sub>2</sub> h4	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	r ±0.005	α	z	
040	0.40	6.00	0.35	61	0.40	8.00	19.20	0.050	8.7°	2	●
048	0.50	6.00	0.45	61	0.50	10.00	21.01	0.050	7.8°	2	●
058	0.60	6.00	0.55	61	0.60	12.00	22.83	0.050	7.0°	2	●
078	0.80	6.00	0.75	66	0.80	16.00	26.45	0.050	5.8°	2	●
096	1.00	6.00	0.95	69	1.00	20.00	30.08	0.050	4.9°	2	●
050	0.50	6.00	0.45	61	0.50	10.00	21.01	0.100	7.8°	2	●
060	0.60	6.00	0.55	61	0.60	12.00	22.83	0.100	7.0°	2	●
080	0.80	6.00	0.75	66	0.80	16.00	26.45	0.100	5.8°	2	●
098	1.00	6.00	0.95	69	1.00	20.00	30.08	0.100	4.9°	2	●
138	2.00	6.00	1.90	87	2.00	40.00	48.31	0.100	2.5°	2	●
082	0.80	6.00	0.75	66	0.80	16.00	26.45	0.200	5.8°	2	●
100	1.00	6.00	0.95	69	1.00	20.00	30.08	0.200	4.9°	2	●
120	1.50	6.00	1.40	80	1.50	30.00	39.24	0.200	3.4°	2	●
140	2.00	6.00	1.90	87	2.00	40.00	48.31	0.200	2.5°	2	●
180	3.00	6.00	2.80	105	3.00	60.00	66.63	0.200	1.4°	2	●
185	3.00	6.00	2.80	105	3.00	60.00	66.63	0.500	1.4°	2	●

Application	Material	d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=15000 min <sup>-1</sup> vf [mm/min]	n=25000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]	n=45000 min <sup>-1</sup> vf [mm/min]
	Graphite  	0.40	2	0.003	0.060	0.100	90	150	180	270
		0.50	2	0.004	0.080	0.100	120	200	240	360
		0.60	2	0.005	0.100	0.100	150	250	300	450
		0.80	2	0.007	0.100	0.150	210	350	420	630
		1.00	2	0.008	0.150	0.200	240	400	480	720
		1.50	2	0.012	0.250	0.300	360	600	720	1080
		2.00	2	0.016	0.300	0.400	480	800	960	1440
		3.00	2	0.025	0.450	0.600	750	1250	1500	2250
	Graphite  	0.40	2	0.004	0.020	0.030	120	200	240	360
		0.50	2	0.005	0.030	0.040	150	250	300	450
		0.60	2	0.006	0.040	0.050	180	300	360	540
		0.80	2	0.007	0.050	0.060	210	350	420	630
		1.00	2	0.009	0.060	0.080	270	450	540	810
		1.50	2	0.014	0.090	0.120	420	700	840	1260
		2.00	2	0.019	0.120	0.160	570	950	1140	1710
		3.00	2	0.028	0.180	0.240	840	1400	1680	2520
	Graphite  	0.40	2	0.004	0.020	0.020	120	200	240	360
		0.50	2	0.005	0.030	0.030	150	250	300	450
		0.60	2	0.006	0.040	0.040	180	300	360	540
		0.80	2	0.007	0.050	0.050	210	350	420	630
		1.00	2	0.009	0.060	0.060	270	450	540	810
		1.50	2	0.014	0.090	0.090	420	700	840	1260
		2.00	2	0.019	0.120	0.120	570	950	1140	1710
		3.00	2	0.028	0.180	0.180	840	1400	1680	2520